

SETUP & OPERATION MANUAL

FEATURES & SPECIFICATIONS

- Steel frame and heavy duty base for greater stability.
- High quality conveyor belt for longer service life.
- Large hand wheel adjusts conveyor table height.
- Graduated depth scale in both inches and metric to indicate sanding thickness.
- Magnetic safety switch.
- Two (2) 4" dust outlets.
- Conveyor belt equipped with removable key safety switch.
- Variable speed conveyor belt.

MAXIMUM SANDING WIDTH

24" (610 mm)

MAXIMUM SANDING THICKNESS

5" (127 mm)

MINIMUM SANDING THICKNESS

1/4" (6 mm)

DRUM DIAMETER

5" (127 mm)

DRUM SPEED

1550 RPM

FEEDING SPEED

3 to 20 FPM (0.93 - 6.2 M/MIN) Variable

MAIN MOTOR

2 HP, 220V, 1 Ph, 9 A

CONVEYOR MOTOR

1/6 HP, 180V, 1A

WEIGHT

495 LBS (225 kg)

24" HORIZONTAL DRUM SANDER



MODEL #15-150 MI





GENERAL® INTERNATIONAL

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THANK YOU

for choosing this General® International model 15-150 M1 Horizontal Drum Sander. This machine has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. To ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this horizontal drum sander as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

GENERAL ® INTERNATIONAL WARRANTY

All component parts of General® International machinery are carefully tested and inspected during all stages of production, and each machine is thoroughly inspected upon completion of assembly. Because of our commitment to quality and customer satisfaction, General® International agrees to repair or replace, within a period of 24 months from date of purchase, any genuine part or parts which, upon examination, prove to be defective in workmanship or material. In order to obtain this warranty, all defective parts must be returned freight pre-paid to General® International Mfg. Co., Ltd. Repairs attempted without our written authorization will void this warranty.

Disclaimer: The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corresponds with that of the unit

with which it was supplied. However, special orders and "after factory" modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this horizontal drum sander and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your machine exactly. If you have any doubts or questions contact your retailer or our support line with the model and serial number of your unit for clarification.

Rules for Safe Operation

To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and hold itself harmless for any injury that may result from the improper use of its equipment.

1. Do not operate the sander when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.
2. The working area should be well lit, clean and free of debris.
3. Keep children and visitors at a safe distance when the sander is in operation; do not permit them to operate the sander.
4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.
5. Stay alert! Give your work your undivided attention. Even a momentary distraction can lead to serious injury.
6. Fine particulate dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector and wear eye, ear and respiratory protection devices.
7. Do not wear loose clothing, gloves, bracelets, necklaces or other jewelry while the sander is in operation.
8. Be sure that adjusting wrenches, tools, drinks and other clutter are removed from the machine and/or the feed table surface before operating.
9. Keep hands well away from the sanding drum and all moving parts. Use a brush, not hands, to clear away chips and dust.
10. Be sure sanding belts are securely installed in the machine.
11. Do not operate the sander if the sand paper is damaged or badly worn.
12. Do not push or force the workpiece into the sander. The machine will perform better and more safely when working at the feed rate for which it was designed.
13. Avoid working from awkward or off balance positions. Do not overreach and keep both feet on floor.
14. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning, be sure it is properly re-attached before using the tool again.
15. Never leave the machine unattended while it is running or with the power on.
16. Use of parts and accessories NOT recommended by General® International may result in equipment malfunction or risk of injury.
17. Never stand on the machine. Serious injury could occur if the sander is tipped over or if the sanding drum is unintentionally contacted.
18. Always disconnect the tool from the power source before servicing, changing accessories or sanding belts, or before performing any maintenance or cleaning, or if the machine will be left unattended.
19. Make sure that switch is in "OFF" position before plugging in the power cord.
20. Make sure the tool is properly grounded. If equipped with a 3-prong plug it should be used with a three-pole receptacle. Never remove the third prong.
21. Do not use this sander for other than its intended use. If used for other purposes, General® International disclaims any real implied warranty and holds itself harmless for any injury, which may result from that use.


ELECTRICAL REQUIREMENTS



Before connecting the machine to the power source, verify that the voltage of your power supply corresponds with the voltage specified on the I.D. nameplate located on the back of the machine. A power source with greater voltage than needed can result in serious injury to the user as well as damage to the machine. If in doubt, contact a qualified electrician before connecting to the power source.

This tool is for indoor use only. Do not expose to rain or use in wet or damp locations.

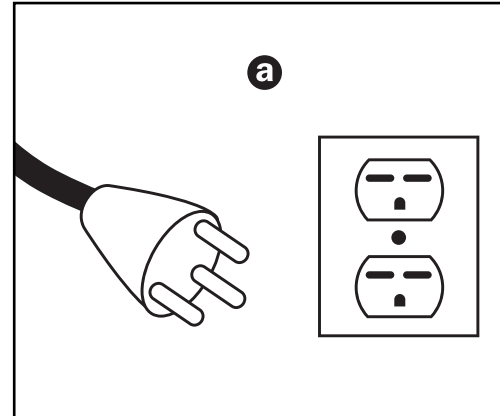
GROUNDING INSTRUCTIONS

In the event of an electrical malfunction or short circuit, grounding reduces the risk of electric shock to the operator. The motor of this machine is wired for 220V single phase operation and is equipped with a 3-conductor cord and a 3-prong grounded plug to fit a matching grounded type receptacle, .

DO NOT MODIFY THE PLUG PROVIDED

If it will not fit your receptacle, have the proper receptacle installed by a qualified electrician.

Check with a qualified electrician or service person if you do not completely understand these grounding instructions, or if you are not sure the tool is properly grounded.



CIRCUIT CAPACITY





Make sure that the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician. If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified technician or our service department.

EXTENSION CORDS

The use of an extension cord is not generally recommended for 220V. If you find it necessary, use only 3-wire extension cords that have 3-prong grounding plug and a matching 3-pole receptacle that accepts the tool's plug. Repair or replace a damaged extension cord or plug immediately.

If you find it necessary to use an extension cord with your machine make sure the cord rating is suitable for the amperage listed on the motor I.D. plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. The accompanying chart shows the correct size extension cord to be used based on cord length and motor I.D. plate amp rating. If in doubt, use the next heavier gauge. The smaller the number, the heavier the gauge.

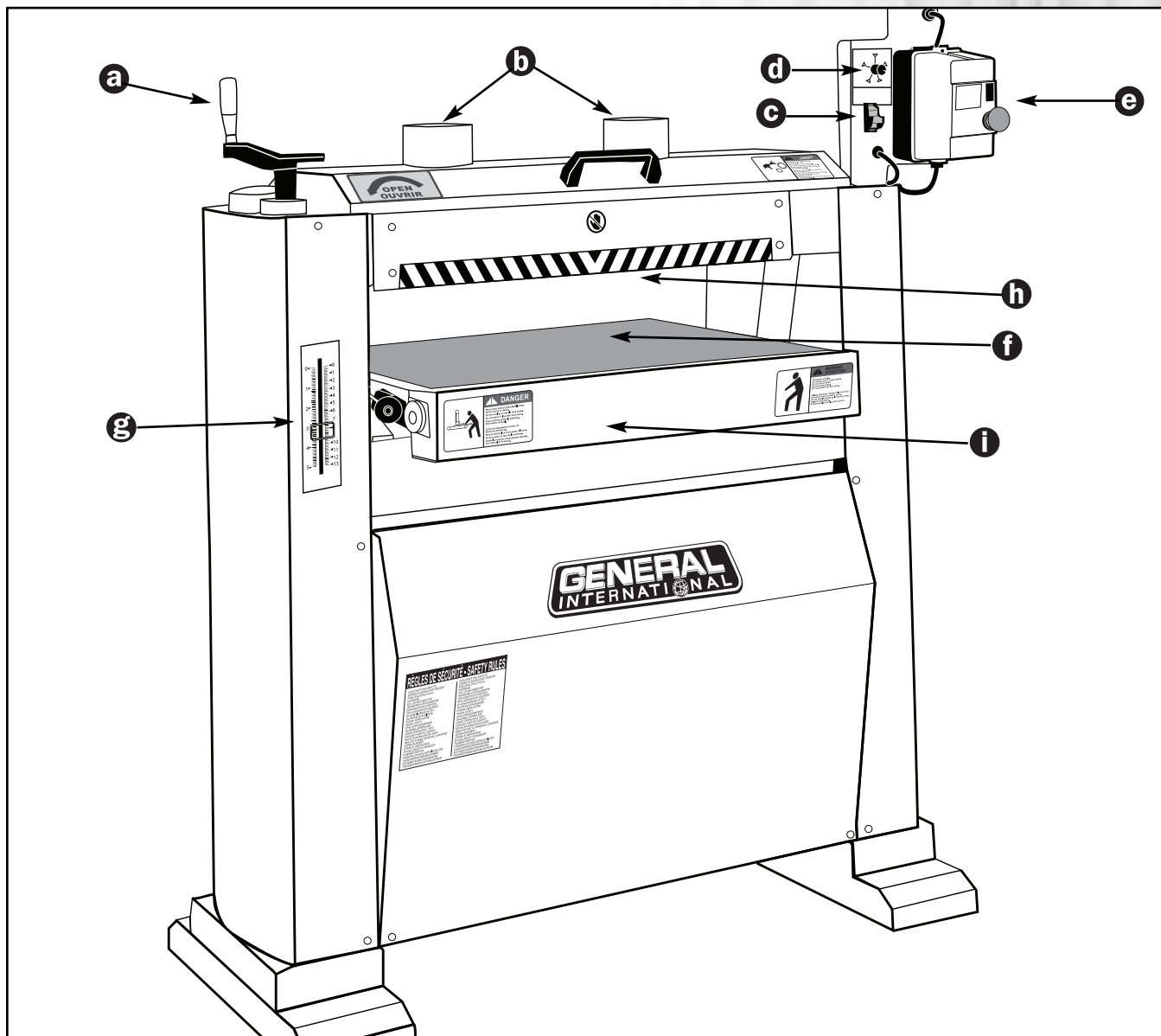
TABLE - MINIMUM GAUGE FOR CORD

AMPERE RATING		VOLTS	TOTAL LENGTH OF CORD IN FEET			
		110 V	25 ft.	50 ft.	100 ft.	150 ft.
MORE THAN	NOT MORE THAN	220 V	50 ft.	100 ft.	200 ft.	300 ft.
		AWG				
0	6		18	16	16	14
6	10		18	16	14	12
10	12		16	16	14	12
12	16		14	12	-	-



24" HORIZONTAL DRUM SANDER 15-150 M1

IDENTIFICATION OF MAIN PARTS AND COMPONENTS



- a** CRANK HANDLE
- b** DUST OUTLET
- c** CONVEYOR MOTOR START/STOP SWITCH WITH SAFETY KEY
- d** CONVEYOR BELT SPEED ADJUSTING KNOB
- e** SANDING DRUM MOTOR MAGNETIC POWER SWITCH
- f** CONVEYOR BELT
- g** DEPTH GAUGE
- h** DRUM (UNDER DRUM COVER)
- i** CONVEYOR TABLE

UNPACKING

Carefully unpack and remove the unit and its components from its shipping container and check for missing or damaged items as per the list of contents below.

NOTE: Please report any damaged or missing items to your **GENERAL® INTERNATIONAL** distributor immediately.

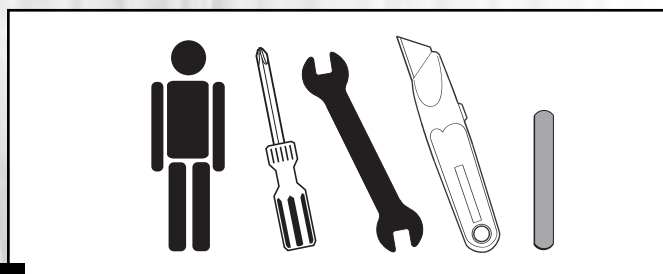
LIST OF CONTENTS

Once the parts have been removed from the packing, you should have the following items:

	QTY
a 24" HORIZONTAL DRUM SANDER	1
b HARDWARE BAG (from left to right)	
— HANDLE KNOB	1
— CRANK HANDLE	1
— 5 MM ALLEN KEY	1
— 6 MM T-HANDLE ALLEN WRENCH	1
— 2 MM T-HANDLE ALLEN WRENCH	1
— 12-14 MM COMBINATION WRENCH	1



ADDITIONAL REQUIREMENTS FOR SET UP



- Extra person for help with lifting
- Phillips Screwdriver
- 10 mm open end wrench
- Utility knife
- Flat piece of wood or any similar non-cutting object

PLACEMENT WITHIN THE SHOP / ESTABLISHING A SAFETY ZONE



This sander is heavy. Do not over-exert. The help of an assistant will be needed for the following step.

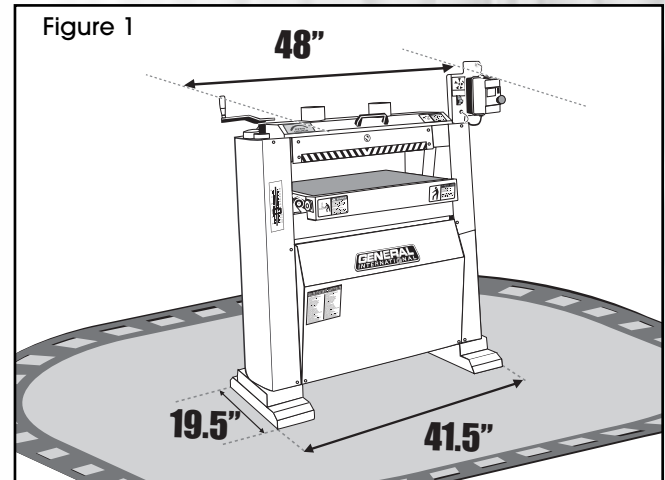
To limit the risk of serious injury or damage to the machine, any equipment used to lift this machine (forklift or lifting hook) should have a rated capacity in excess of 495 lbs (225 kg).

PLACEMENT WITHIN THE SHOP

This machine should be installed and operated only on a solid, flat and stable floor that is able to support the weight of the sander (495 lbs/225 kg) and the operator. Using the dimensions shown in *Figure 1* as a guideline, plan for placement within your shop that will allow the operator to work unencumbered and unobstructed by foot traffic (either passing shop visitors or other shop workers) or other tools or machinery.

ESTABLISHING A SAFETY ZONE

For shops with frequent visitors or multiple operators, it is advisable to establish a Safety Zone around shop machinery. A clearly defined “no-go” zone on the floor around each machine can help avoid accidents that could cause injury to either the operator or the shop visitor. It is advisable to take a few moments to either paint (using non-slip paint) or using tape, define on the floor the limits or perimeter of each machine's safety zone. Take steps to ensure that all operators and shop visitors are aware that these areas are off limits whenever a machine is running for everyone but the individual operating the unit.



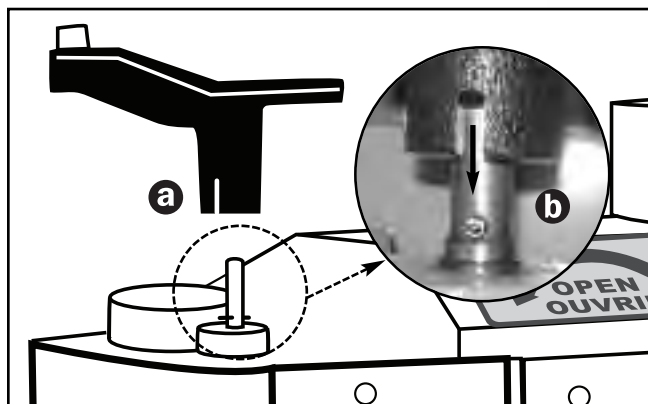
ASSEMBLY INSTRUCTIONS

For your convenience this sander is shipped from the factory partially assembled and requires only minimal assembly and set up before being put into service.

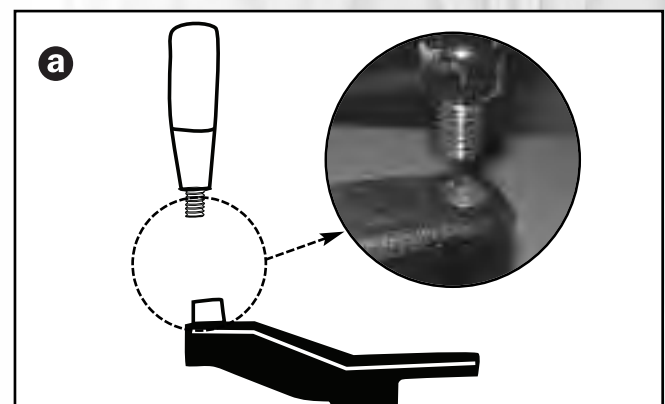


Do not plug in or turn on the sander until you have completed the installation and assembly steps described in this section of the manual.

INSTALL THE CONVEYOR TABLE ELEVATION CRANK HANDLE

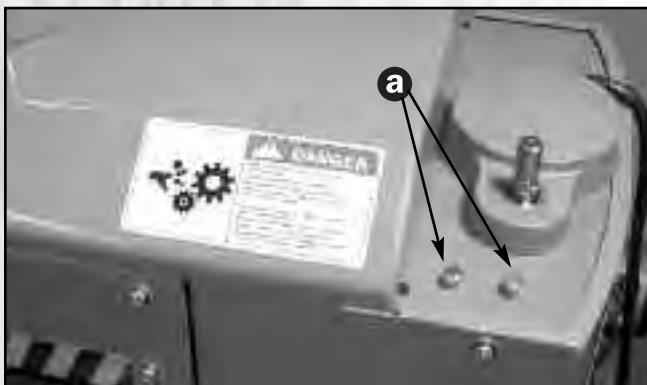


1. Install the conveyor table adjustment crank handle, **a**, on the shaft located on the top left end of the sander. The slots in the crank handle must be aligned with the spring pin on the shaft, **b**.



2. Screw the knob, **a**, into the threaded hole in the crank handle.

INSTALL THE CONTROL BOX



1. Loosen, but do not remove, the 2 hex bolts, **a**, installed on the top right hand corner of the machine.



2. Slide the control box onto the heads of the bolts.



3. Tighten the bolts to secure the control box in place, with a 10 mm open end wrench.

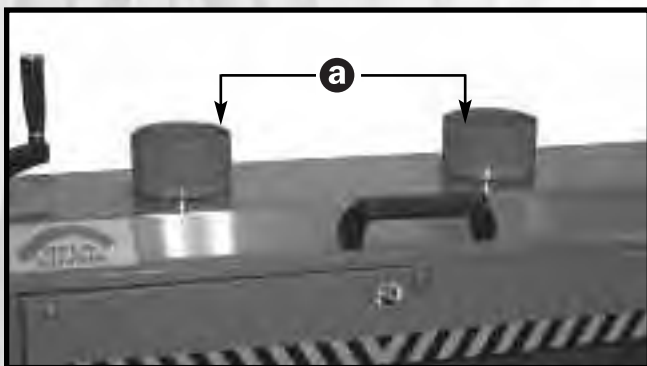


Do not plug in the power cord yet.

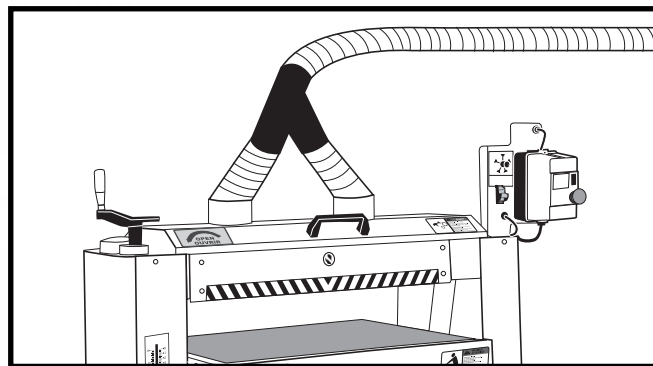
CONNECTING TO A DUST COLLECTOR



Do not operate this sander without an adequate dust collection system properly installed and running. Operating this sander without adequate dust collection can lead to equipment malfunction or dangerous situations for the operator or other individuals in the workshop.



The 24" horizontal drum sander is equipped with two 4" diameter dust outlets, **a**, on top of the machine, allowing for the connection to a dust collector (not included).



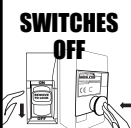
Be sure to use appropriate sized hose and fittings (not included) and check that all connections are sealed tightly to help minimize airborne dust.

Note: Recommended dust collection CFM requirements for this sander is 1500 CFM.


If you do not already own a dust collection system consider contacting your General® International distributor for information on our complete line of dust collection systems and accessories or visit our Web Site at: www.general.ca.

BASIC ADJUSTMENTS AND CONTROLS

CONNECTING TO A POWER SOURCE

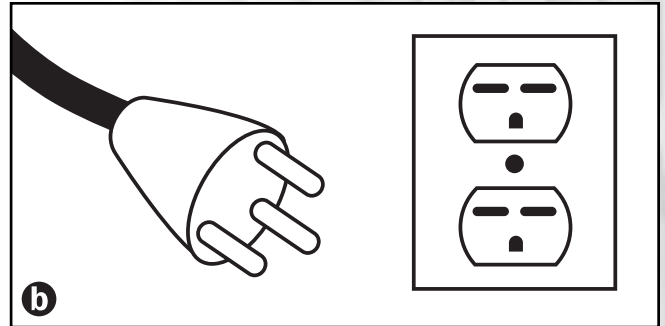


SWITCHES OFF



To avoid risk of shock or fire do not operate the unit with a damaged power cord or plug. Replace damaged cord or plug immediately.

To avoid unexpected or unintentional start-up, make sure that both of the power switches on the sander are in the OFF position before connecting to a power source.

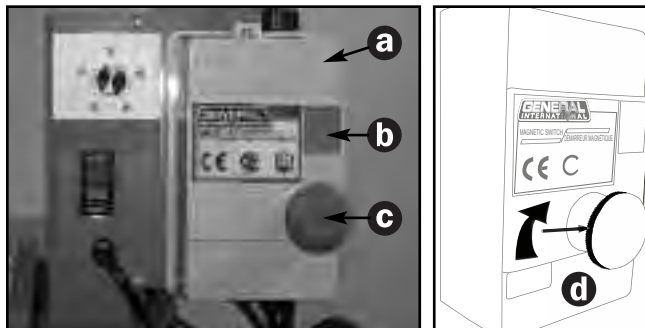


Once the assembly steps have been completed, uncoil the power cord, **(a)**, and plug it into an appropriate outlet, **(b)**, (refer back to the section entitled "Electrical Requirements" and make sure all requirements and grounding instructions are followed).

ON/OFF POWER SWITCHES

This sander is equipped with 2 different ON/OFF power switches: one magnetic switch for the drum motor and one switch with a safety key for the conveyor motor.

DRUM MOTOR MAGNETIC SWITCH

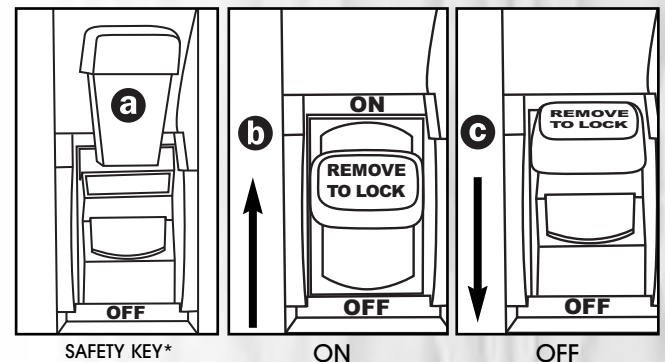


This model 15-150 M1 drum sander is equipped with a MAGNETIC SAFETY SWITCH, **(a)**, located on the control box designed to protect the unit and the user from power surges, power outages and unwanted or unintentional start-up.

The switch assembly is equipped with a GREEN "START" button, **(a)**, and a RED spring loaded "STOP" button, **(b)**.

Once the RED "STOP" button has been pressed, the machine can only be started by turning the BLACK inner part of the button to the right to release the stop button, **(c)**.

CONVEYOR MOTOR SWITCH WITH SAFETY KEY



*** PREVENTS START-UP WHEN REMOVED**

This model 15-150 M1 is also equipped with a simple ON/OFF switch for the conveyor motor, featuring a removable lock out safety key.

To start the conveyor belt, insert the safety key, **(a)** and lift the switch up, **(b)**. To stop the machine, pull the switch down, **(c)**.

To prevent unauthorized use or unintentional start-up, remove the safety key and store it in a safe place whenever the sander is not in use.



Remove the switch key and store it in a safe place, out of the reach of children, whenever the sander is not in use.

OVERLOAD PROTECTION

The magnetic safety switch on this sander is equipped with an overload protection feature. To prevent an electrical overload from damaging the motor, in the event of a spike in line voltage or amperage draw, the internal overload protector will automatically be tripped, thereby cutting off power to the motor.

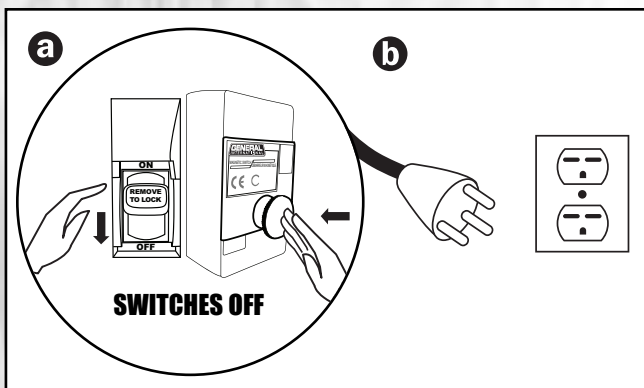
Note: The most common causes of such overloads are:

1. **Overworking the motor by attempting to remove too much material in a single pass, thereby causing an increase in power consumption and a spike in amperage draw.**
2. **An electrical extension cord that is too long or not the correct gauge of wire, which can also cause an increase in amperage draw. If an electric extension cord must be used, follow the instructions and refer to the chart in the electrical requirements section at the beginning of this manual.**
3. **Overworked circuit caused by operating on a circuit that is close to its amperage draw capacity. Make sure the circuit being used is capable of handling the amperage draw from this machine as well as any other electrical devices operating on the same circuit. If you are unsure, consult a qualified electrician.**

To reset the overload protection switch after it has been tripped proceed as follows:

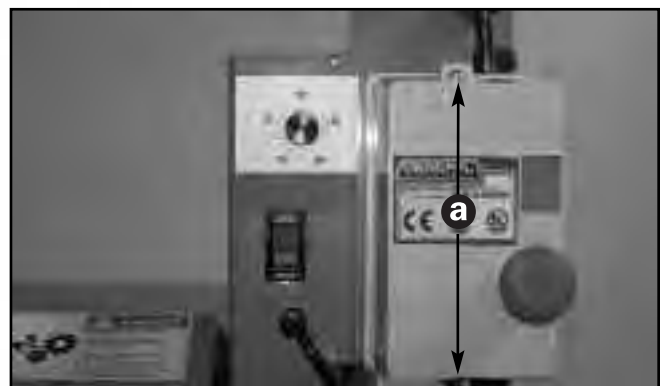


To avoid unexpected or unintentional start-up be certain that both of the power switches have been set to the off position before re-setting the overload protection switch.



1. Set both of the power switches on the sander to the off position, **a**, and disconnect the machine from the power source, **b**.

Note: If the sander is permanently connected to a circuit (hard-wired), set the wall panel circuit breaker or main circuit interrupter to the off position.



2. Unscrew the 2 screws, **a**, and remove the control box front cover.



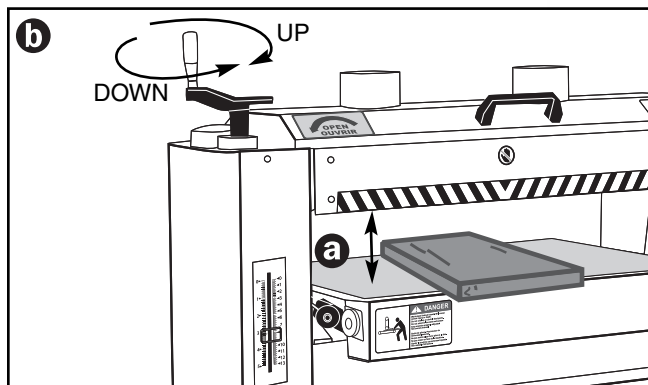
3. Press the blue reset button, **a**.

4. Reinstall and rescrew the control box cover.
5. Reconnect the sander to the power source.
6. You can now restart the drum motor by pushing on the green button ON.

RAISING/LOWERING THE CONVEYOR TABLE

The conveyor table can be raised or lowered, **a**, as needed to suit the thickness of the workpiece, by rotating the crank handle, **b**.

Note: The maximum workpiece thickness capacity for this machine is 5".

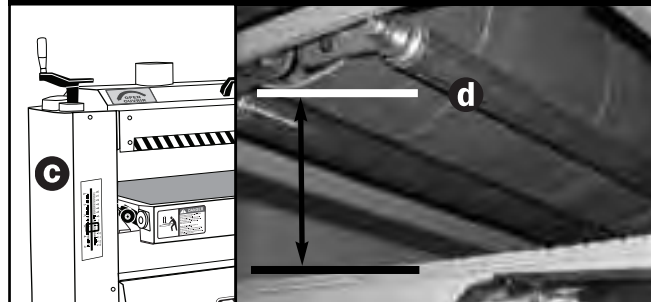


1. Put the workpiece on the conveyor belt.



Never attempt to sand workpieces that are greater than 5".

Note: The depth gauge, **c**, on the front of the machine can be used as a reference but it is not intended for high precision measurements.



2. Set the height of the conveyor table so that the workpiece barely touches the drum, **d**.

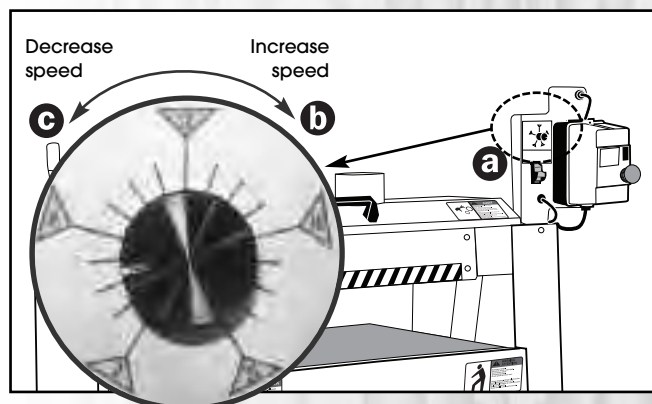
Note: To avoid overworking the motor, creating a potential circuit overload, or damaging the sanding drum, do not force the workpiece against or into the drum.

CHANGING FEED SPEED

The conveyor speed ranges from 3 to 20 FPM (Feet Per minute).

The feed speed adjustment knob, **a**, is located on the control box, on the right hand side of the machine.

- Turn the knob clockwise, **b**, to increase the feed rate.
- Turn the knob counter-clockwise, **c**, to decrease the feed rate.



Experiment with feed speeds based on the workpiece material, depth of sanding as well as sanding belt grit to find which setting work best for your needs. As a general guideline however, for best results, more aggressive sanding using lower grits or sanding wider boards should be done at slower speeds and sanding using higher grits or sanding narrow boards can be done at higher speeds.

BASIC FUNCTIONS OF THE UNIT

This drum sander is designed for surface sanding of wooden cabinet doors, flat wooden panels, wide glue-ups and other natural wood products only. This sander is not intended (and should not be used) to sand any material other than wood.

BASIC PRINCIPLES OF SANDING

It is always preferable to remove less material per pass and take multiple passes. This can extend sanding belt life, place less strain on the motor and provide better workpiece finish quality.



Do not use this sander as a thickness planer. Never attempt to remove more than the depth of the grain of the sanding belt in any single pass. Too much friction will cause belt to overheat and wear prematurely, and, in extreme cases, may cause burns in the workpiece.

Note: To avoid overworking the motor, creating a potential circuit overload, or damaging the sanding drum, do not force the workpiece against or into the drum. For better finish results and to avoid potential damage to the sander or the workpiece, let the workpiece feed into the sander at the rate of feed to which the conveyor is set.

OPERATING INSTRUCTIONS

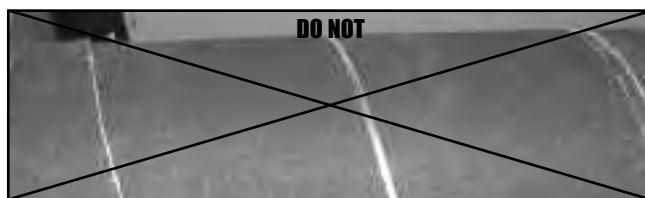
CHECKLIST BEFORE STARTING



Make sure to have on safety glasses as well as hearing and respiratory protection at all times when using the sander.

Make sure you and any assistants are wearing safe appropriate workshop attire. Roll up long sleeves, secure long hair and remove any jewelry: watches, rings, bracelets or anything that could become caught in the conveyor feed rollers or the drum, potentially causing serious injury.

- Make sure a dust collector is properly attached.
- If multiple boards are to be sanded, collect all workpieces together and set them nearby on a table or bench within easy reach.
- Make sure that the sanding belt is properly installed, that is, wound around the drum, taut and without spaces between the belt edges. Otherwise, the sanding belt may rip when in contact with the workpiece.

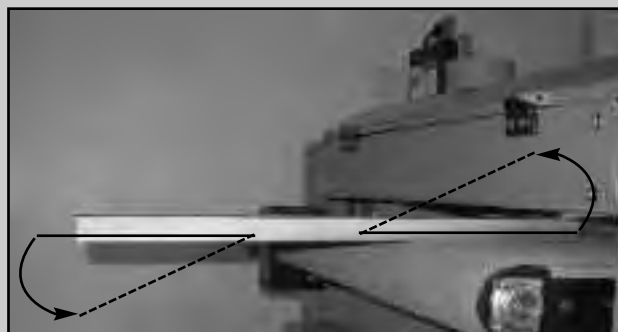


- If working with longer workpieces, make sure to have adequate out feed support safely set-up and ready before sanding.

Tip: To avoid sanding snipe - which is a small depression in the surface of a workpiece across its width caused by a variation in the sanding depth during a given pass - it is important to keep the workpiece level on the feed table until it has completely cleared contact with the sanding drum. It is advisable to use an outfeed table or some form of outfeed support when sanding workpieces of 4' or more in length. Allowing the leading edge of a longer workpiece to hang or sag off of the outfeed end the conveyor table should be avoided as it will lift the trailing end of the workpiece up into the sanding drum and cause uneven sanding depth and snipe.



WITH AN ADEQUATE OUTFEED SUPPORT



WITHOUT AN ADEQUATE OUTFEED SUPPORT

OPERATIONS STEP-BY-STEP



To reduce the risk of damage to the sander or the workpiece, as well as a potential for personal injury, after initial set-up as well as before each use, make sure that everything is securely installed and that all fasteners and moving parts on this sander are locked in place before starting the machine.

1. Place the workpiece on the conveyor belt.
2. Set the height of the conveyor table. (see previous section: "Raising/Lowering the Conveyor Table")
3. Remove the workpiece from the conveyor belt.
4. Turn on your dust collector.



Always turn on the dust collector **BEFORE** starting the sander.

5. Press the green "ON" button on the control box to start sanding drum motor.
6. Insert the safety key into the conveyor belt switch.
7. Set the feed speed to minimum before starting the conveyor belt, then lift the switch up to start the conveyor motor. Gradually increase the speed, until you reach the desired feeding speed.
8. Place the workpiece on the center of the conveyor belt and pass the board twice.



Keep hands away from the rotating drum and conveyor belt. Do not force the workpiece towards the sanding drum, let the conveyor belt feed the workpieces.

Tip: For better workpiece finish quality, make shallower passes with the conveyor table height adjusted so you just start hearing the contact noise.

9. Step to the rear of the machine and pick up the workpiece on the out feed.

Note: Consider using a proper support on the out feed for workpieces longer than 4'.

TO STOP THE MACHINE

1. Press the red "OFF" button, on the control box to stop the rotation of the drum.
2. Push the red switch to the "OFF" position to stop the conveyor belt.
3. Remove the key switch. This will prevent unauthorized use of the machine.
4. Turn your dust collector off.

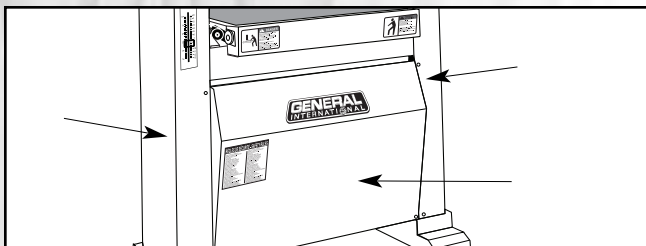


Always turn off the sander **BEFORE** turning off the dust collector.

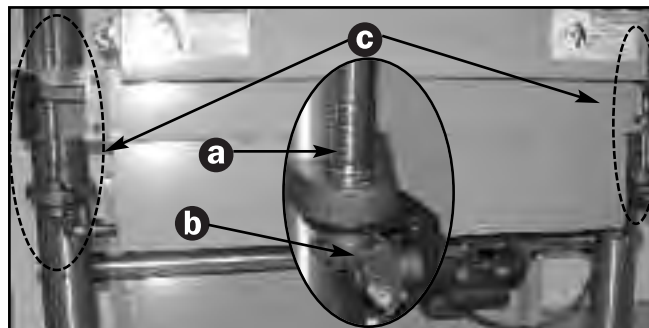
LUBRICATION



Disconnect machine from power source, before performing any maintenance or lubrication.



Note: Unscrew and remove the front panel and both side panels to access the conveyor elevation mechanism.



Keep threaded rods, **a**, and gears, **b**, located at either end of the machine, **c**, greased and free of dust or debris. Clean and remove dust, debris, and old grease after every 10-15 hours of use. After cleaning, re-apply a generous coating of any common automotive bearing grease.

PERIODIC MAINTENANCE

1. Inspect/test the ON/OFF switches before each use. Do not operate the sander with a damaged switch; replace a damaged switch immediately.
2. Keep the machine, especially motor and conveyor, as well as the feed table conveyor clean and free of dust or glue. Vacuum or brush off any loose debris and wipe down the machine and the conveyor occasionally with a damp rag.
3. The drum must always be kept clean. Dirt on the drum will cause belt slippage.
4. The motor and drum bearings are sealed and permanently lubricated – no further lubrication is required.
5. Periodically inspect the power cord and plug for damage, as well as the sanding belt, the drum, the motor pulleys drive belt and the conveyor belt.



Never operate the sander with any damaged part. Replace a damaged part at the first visible signs of damage.

REQUIRED MAINTENANCE

MOUNTING AND REPLACING THE SANDING BELT

Sanding belt should be replaced when worn out.

Pre-cut replacement belts can be purchased in a variety of grits from your General® International dealer under the following parts numbers:

- | | |
|---------------------|---------------------|
| • 36 grit - 15-251 | • 120 grit - 15-255 |
| • 60 grit - 15-252 | • 150 grit - 15-256 |
| • 80 grit - 15-253 | • 180 grit - 15-257 |
| • 100 grit - 15-254 | • 220 grit - 15-258 |

You can also purchase them from your local tool, abrasives or sharpening supply dealer. You can find these products in most areas. However, we recommend that you choose higher quality brand name belts. If the sanding paper is too thick or too thin, or of inconsistent quality, it may not be properly gripped by the spring-loaded clamps.

Tip: *Cleaning the sand paper with a belt dresser will extend the life of the sand paper. Consult your local distributor.*

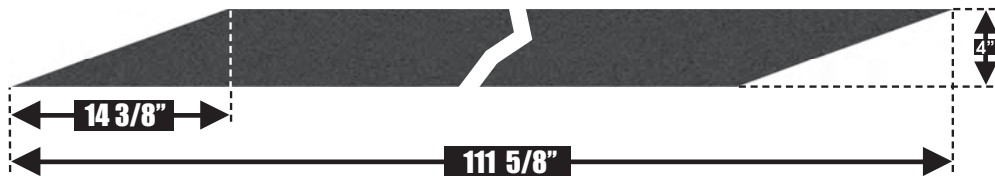
For users who prefer to purchase abrasives in longer uncut rolls or from bulk suppliers, the following cutting diagram can be used to assist in cutting the bulk paper to the correct size for this sander.

DRUM SANDER PAPER DIMENSIONS*

***MEASURED & CUT WITH ABRASIVE GRIT FACE SIDE DOWN**

24" DRUM SANDERS

MODEL #15-150 & 15-250

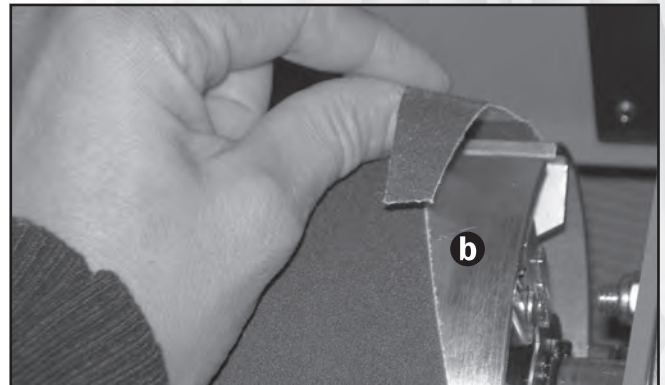
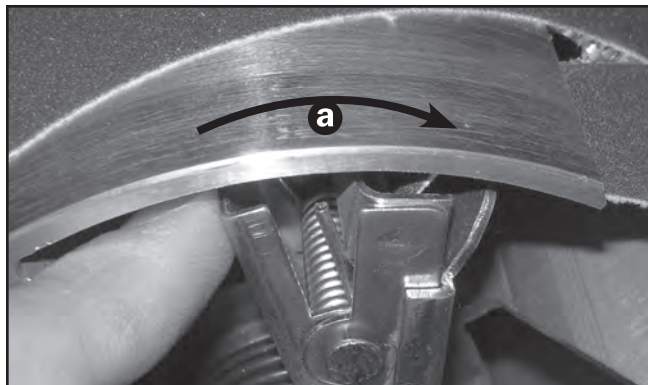
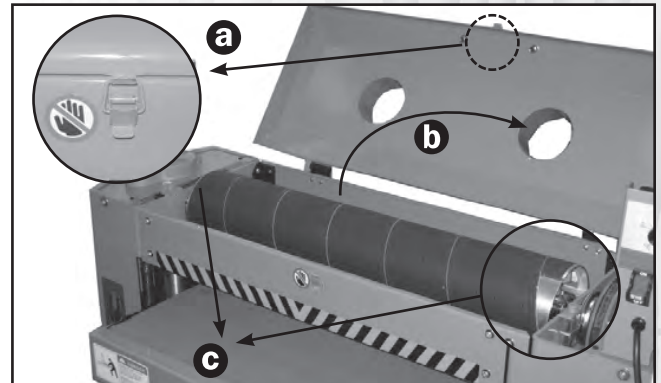


REMOVING THE SANDING BELT



Make sure the sander is disconnected from the power source before removing/mounting the sanding belt.

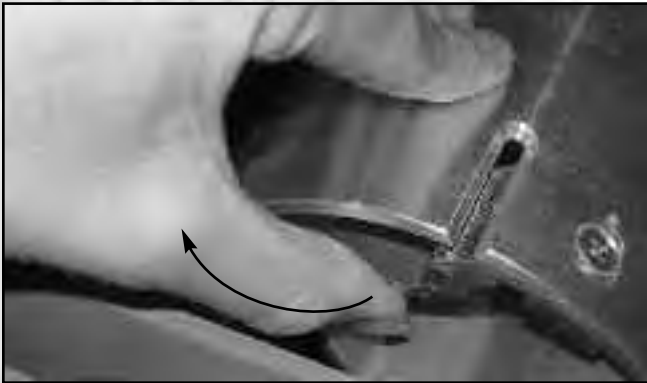
1. To access the sanding belt, unlock the drum cover latch, **a**, then lift up and tilt the cover towards the rear, **b**. The sanding belt is tightly wound around the rotating drum and attached at both ends of the drum by spring-loaded clamps, **c**.



2. Push the right spring-loaded clamp forward, **a**, and remove the tab of the sanding belt from the slot at the right end of the drum, **b**.
3. Unwind the sanding belt then push the left spring-loaded clamp forward and remove the tab of the sanding belt from the slot of the left end of the drum.

MOUNTING A NEW SANDING BELT

Note: To extend belt life and avoid premature breakage, take note of the direction of the arrows printed on the inside of the sanding belt to make sure you install the belt in the correct direction.



1. Pull and hold the left spring-loaded clamp.

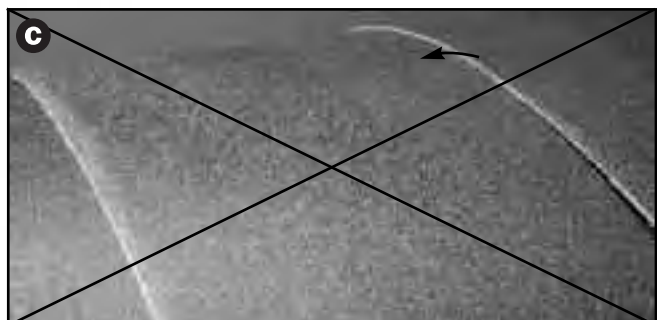
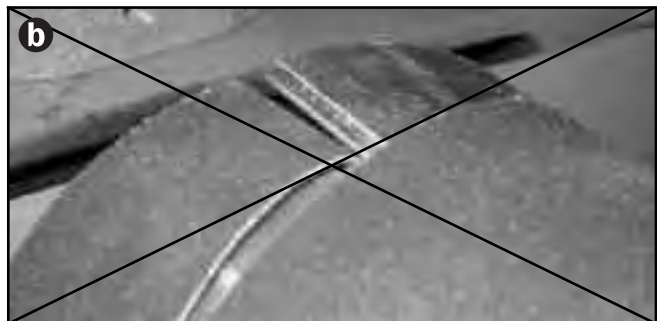
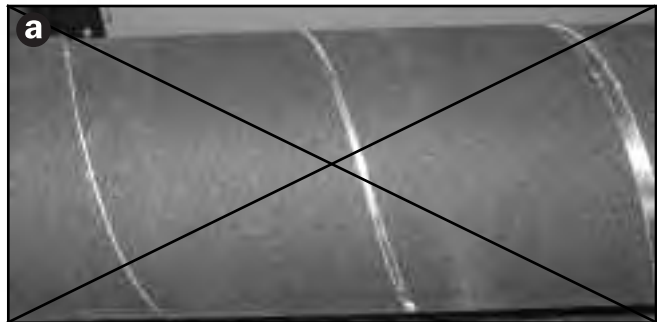


2. Insert the left tab of the sanding belt in the slot, pushing all the way in (as far as possible), then release the clamp to lock the tab in place.

DO

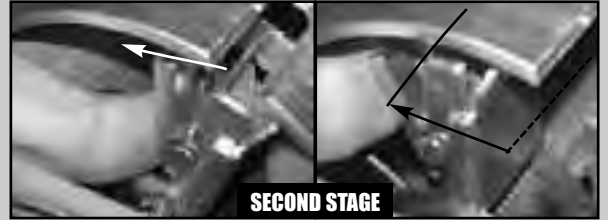


DO NOT

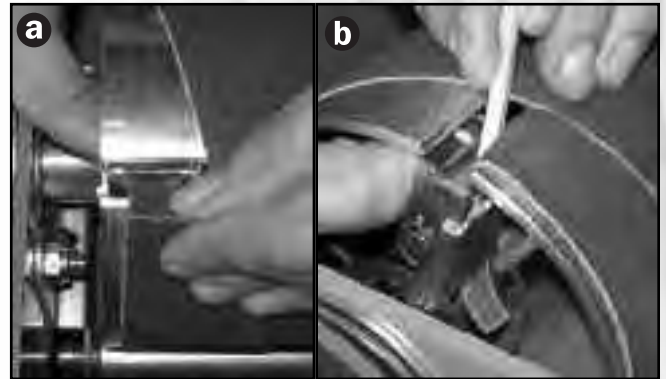


3. Tightly wind the sanding belt around the drum, making sure that there are no spaces between the edges, **a**, of the sanding belt, that the belt is taut and that there are no bumps, **b**. Do not overlap the edges, **c**.

Note: The spring-loaded clamp at the right end of the drum is a two stage spring. The first stage grabs the paper and the second stage pulls the clamp backward inside the drum, providing proper tension to the sanding belt.



5. Push and hold the right spring-loaded clamp forward with your thumb.



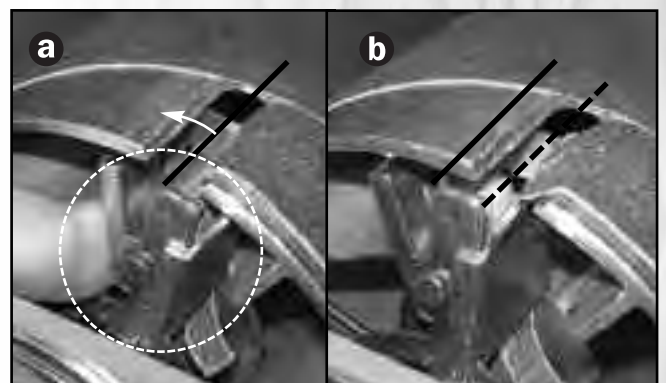
6. Insert the right tab of the sanding belt in the slot, pushing all the way in (as far as possible), until it is tight, **a**.

Tip: Use a flat stick or any similar non-cutting object to force the tab further into the slot so it is as tight as possible, **b**.

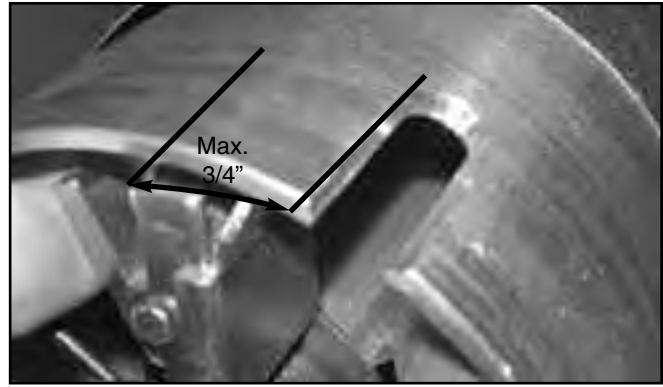
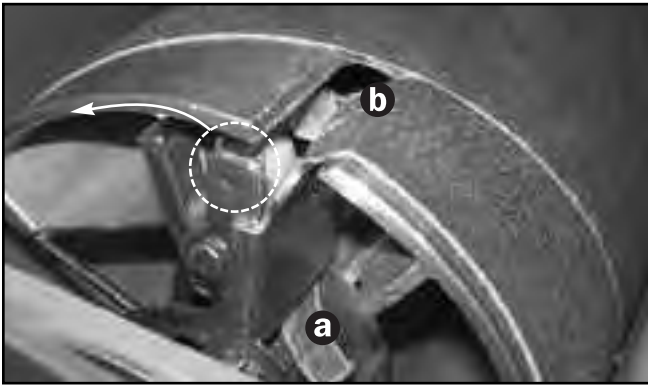
Note: On occasion, due to slight variations in the length of the sanding belt or the depth of installation in the left belt clamp, even with the belt properly wound onto the drum, there may be slightly too much belt left at the right end of the drum. This may cause a slight overlap on the last wrap on the drum, **a**, and this despite installing the right end of the belt as far into the clamp as it will go. In such cases, to avoid having to unroll and realign the entire belt on the drum after it has already been secured at both ends and is otherwise properly installed, use a utility knife or scissors to cut and remove the overlapped section of paper. To avoid belt tearing during sanding, avoid cutting at right angles, **b**, - make a rounded or curved cut, **c**. (See pictures below.)



7. Release **only** the first stage of the clamp, sliding your thumb down towards the bottom to lock the tab in place.



8. Release the clamp, **a**. This will bring proper tension, **b**, to the sanding belt.

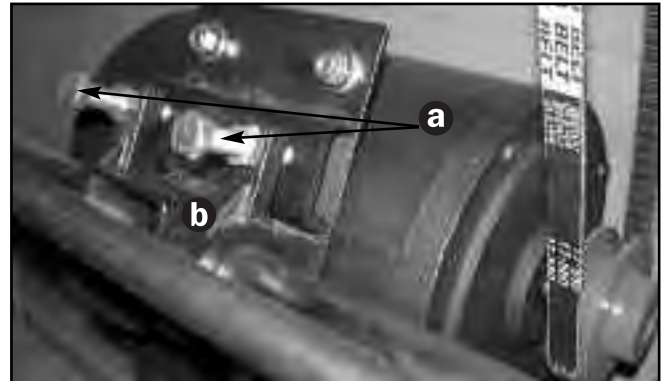
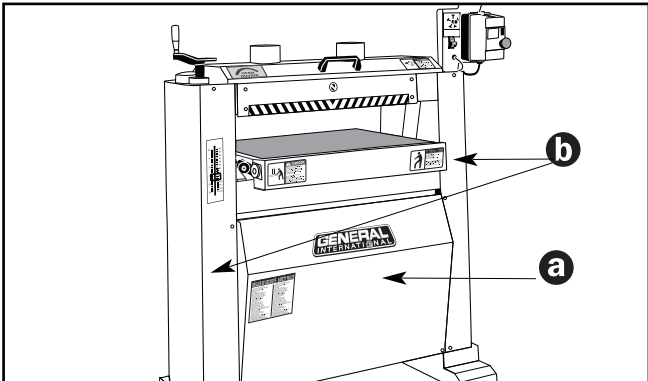


Note: With the sanding belt tab properly inserted in the clamp, the clamp assembly should not pull back more than 3/4" from the slot in the drum. If the clamp assembly pulls back further than 3/4" the sanding belt tab, ❸, needs to be inserted further into the clamp to remove some of the slack in the belt, ❶. Otherwise the paper will not be properly tensioned on the drum and the belt may loosen, unwind, or possibly tear when it comes in contact with the workpiece. (See images above.)

9. Once the sanding belt has been properly installed and tensioned on the drum, close and lock the drum cover.

DRUM MOTOR BELT REPLACEMENT

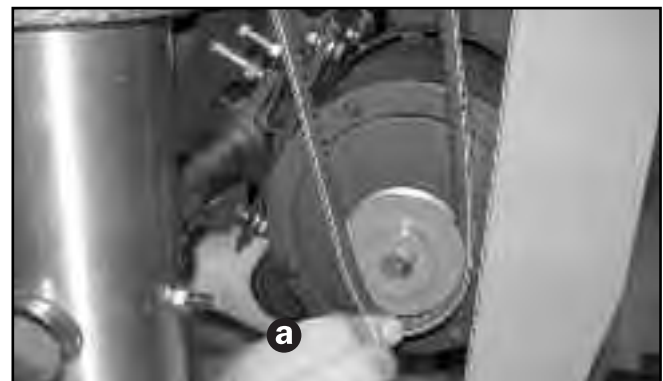
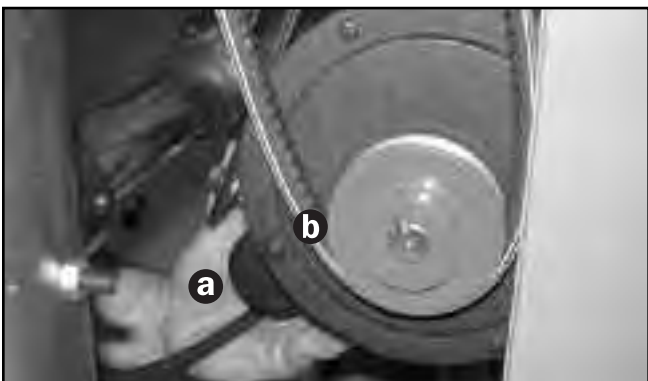
The sanding drum is driven by a belt mounted on pulleys powered by the motor. If the belt becomes too loose due to wear or if a breakage occurs, you must replace it as follows:



1. Unscrew and remove the front panel, ❶, and both side panels, ❷.
2. Loosen but do not remove the hex head bolts, ❸, (with a 14 mm open end wrench), located on the motor positioning ring, ❹.



Proceed with caution. Removing the belt from the pulley will cause the motor to swing freely under it's own weight on the support shaft. Do not let it drop. Hold it until it is back down.



3. Lift the motor up, ❶, with one hand. This will loosen the belt, ❷.
2. With your other hand, carefully remove the belt from the lower pulley, ❸.

5. Remove the belt from the upper pulley, **a**, and install a new belt. (See image right.)
6. Lift the motor up with one hand and install the other end of the belt on the lower pulley with the other hand.
7. Put the motor back to its initial position, then retighten the hex bolts located on the motor positioning ring.

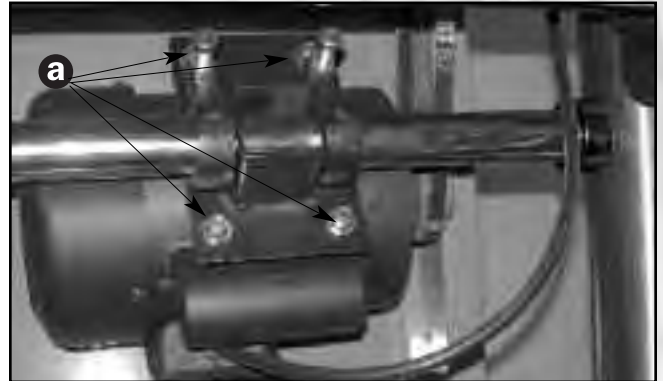


REPLACING MOTOR



Never attempt to repair motor yourself. Contact a qualified technician.

Should the motor require replacement, remove the 4 bolts on the bottom of the motor base plate, **a**, and remove the entire motor assembly.



RECOMMENDED OPTIONAL ACCESSORIES FOR YOUR SANDER

We offer a large variety of products to help you increase productivity, accuracy and safety when using your sander. Here's a small sampling of accessories available from your local General International dealer. For a complete list, visit our website at www.general.ca.



Sanding belts

15-251 - 36 Grit
15-252 - 60 Grit
15-253 - 80 Grit
15-254 - 100 Grit
15-255 - 120 Grit
15-256 - 150 Grit
15-257 - 180 Grit
15-258 - 220 Grit



Dust Collector

We have a wide selection of dust collectors to suit all your shop needs. Dust collectors contribute to a cleaner and more healthful workshop environment.



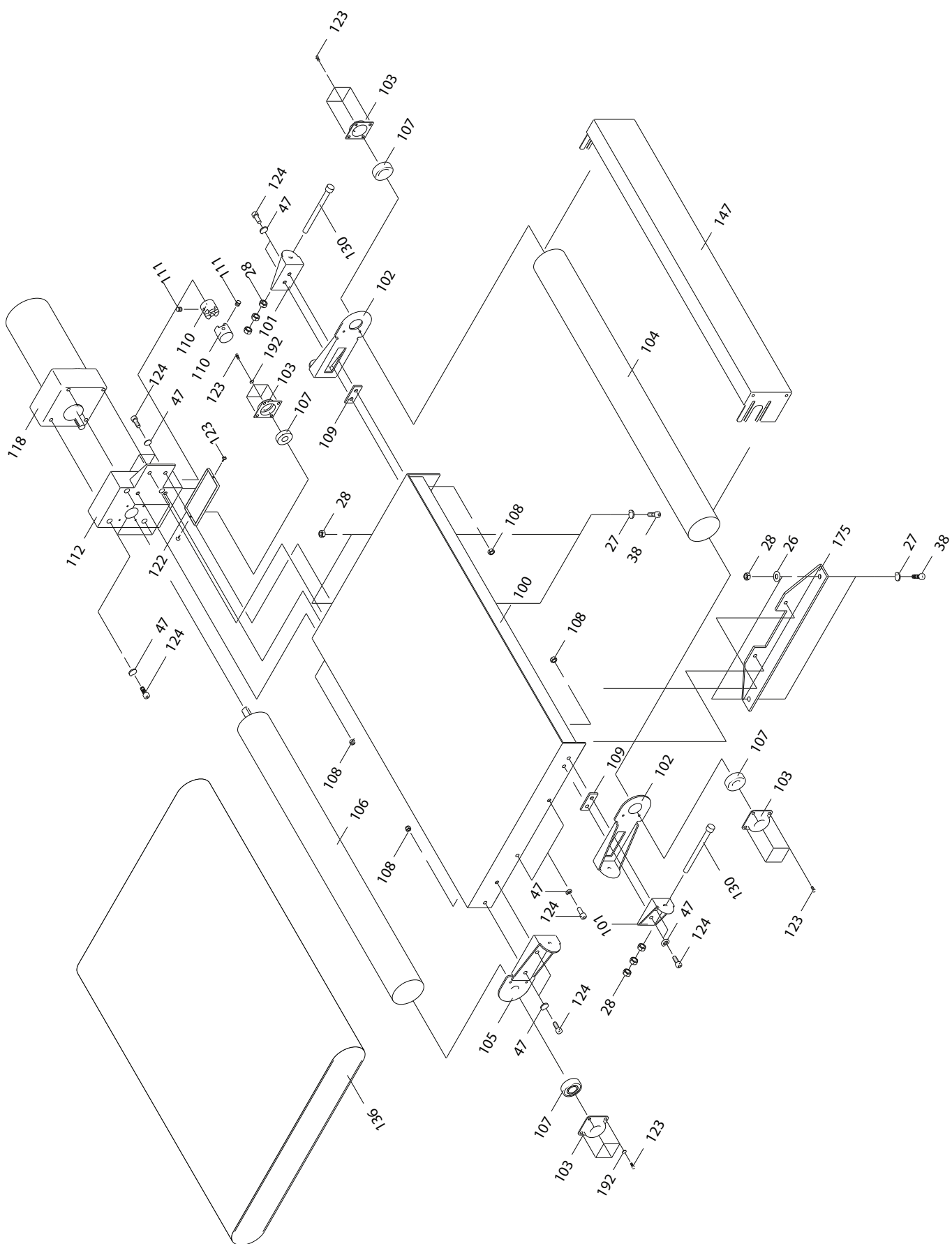
Mobile base model 50-025

Easily roll your table saw anywhere in your shop. Load capacity: 500 lbs. Wheels lock when equipment is in use.



Flexible, expandable 2-way roller stand. Model 50-167S

Ideal for use for infeed or outfeed support. 20" wide, height from 24 1/4" to 37", and length from 21" to 51". Four 4" high quality swivel casters with locking foot levers. 300 lbs load capacity.



PARTS LIST - 15-150 M1

PART NO.	DESCRIPTION	SPECIFICATION	QTY
15150-01	DRUM		1
15150-02	TWO-STEP CLAMP		1
15150-03	TWO-STEP CLAMP PLATE		1
15150-04	SPRING		1
15150-05	SPRING		1
15150-06	FIXED CLAMP BRACKET		1
15150-07	FIXED CLAMP PLATE		1
15150-08	SPRING		1
15150-09	PHILLIPS HEAD SCREW		1
15150-10	NUT	3/16"-24UNC	6
15150-11	RIGHT CLAMP		2
15150-12	LEFT CLAMP		2
15150-13	MICRO-ADJUSTMENT SPRING		4
15150-14	PHILLIPS HEAD SCREW		4
15150-15	NYLON NUT	M5X0.8	4
15150-16	CLAMP BLOCK		2
15150-17	RIGHT BEARING HOUSING		1
15150-18	LEFT BEARING HOUSING		1
15150-23	BEARING CAP		4
15150-24	BEARING	6205	2
15150-25	CAP SCREW		4
15150-26	FLAT WASHER		12
15150-27	LOCK WASHER	5/16"	22
15150-28	NUT	5/16"-18UNC	20
15150-30	FLAT WASHER	3/8"X23	1
15150-31	LEFT THREADED SCREW	5/16"-18UNCX1"L	1
15150-32	CORNER BRACKET		4
15150-33	FRONT UPPER PANEL		1
15150-34	DUST HOOD SUPPORT PANEL		1
15150-35	HINGE		2
15150-36	DUST HOOD		1
15150-37	DUST HOOD HANDLE		1
15150-38	CAP SCREW	5/16"-18UNCX3/4"L	6
15150-39	UPPER CLASP		1
15150-40	LOWER CLASP		1
15150-41	HINGE PAD	SS41	2
15150-42	PHILLIPS HEAD SCREW	1/4"-20UNC	32
15150-43	FLAT WASHER	1/4"X13X1	32
15150-45	PULLEY GUARD		1
15150-47	LOCK WASHER	1/4"	54
15150-48	UPPER BRACKET		2
15150-49	COLUMN SUPPORT BRACKET		2
15150-50	LOWER BRACKET		2
15150-51	WORM GEAR		2
15150-52	WORM		2
15150-53	BUSHING		2
15150-54	CIRCLIP	S80	4
15150-55	SET SCREW		26
15150-56	SET SCREW		16
15150-57	SCREW HOLDER		2
15150-58A	BEARING	51102	2

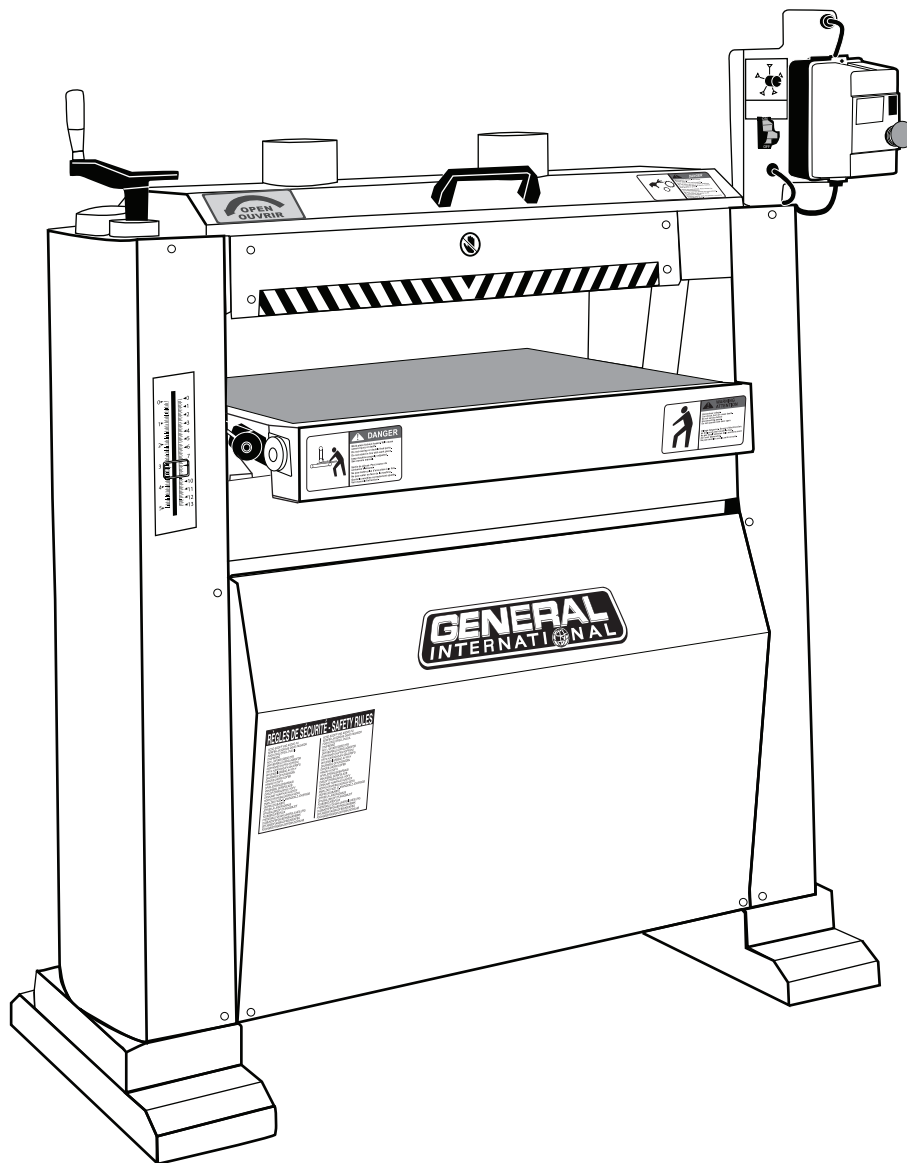
PARTS LIST - 15-150 M1

PART NO.	DESCRIPTION	SPECIFICATION	QTY
15150-58	BRONZE COLLAR		2
15150-59	BEVEL GEAR		4
15150-62	GEAR SHAFT BUSHING		2
15150-63	POSITIONING COLLAR		2
15150-63A	POSITIONING COLLAR	34	2
15150-64	TRANSMISSION SHAFT		1
15150-68	PHILLIPS HEAD SCREW	5/16"-18UNCX1"L	8
15150-69	BRONZE COLLAR COVER		2
15150-70	CIRCLIP	S15	2
15150-71	PIN	4X20	1
15150-72	CRANK HANDLE		1
15150-73	HANDLE KNOB		1
15150-74	SWITCH MOUNTING PLATE		1
15150-75	MAGNETIC SWITCH		1
15150-76	SCREW	3/16"-24UNCX3/4"L	4
15150-77	FLAT HEAD SCREW		3
15150-78	CORD BUSHING		1
15150-79	SWITCH REAR GUARD		1
15150-80	MOTOR BASE		1
15150-81	HEX HEAD BOLT		8
15150-83	MOTOR		1
15150-84	DRIVE PULLEY		1
15150-84A	DRIVE ROLLER		1
15150-85	KEY	6X40	1
15150-86	KEY	5X30	1
15150-91	FRONT TABLE SUPPORT		1
15150-92	REAR TABLE SUPPORT		1
15150-93	CAP SCREW	5/16"-18UNCX1/2"	8
15150-95	CAP SCREW	1/4"X1/2"	8
15150-96	RIGHT COVER		1
15150-97	LEFT COVER		1
15150-98	GRADUATED SCALE		1
15150-99	INDICATOR		1
15150-100	BELT PLATEN		1
15150-101	MICRO-ADJUSTMENT BLOCK		2
15150-102	MICRO-ADJUST. MOUNTING BRACKET		2
15150-103	BEARING CAP	6202	4
15150-104	FRONT CONVEYOR ROLLER		1
15150-105	POSITIONING PLATE		1
15150-106	CONVEYOR DRIVE ROLLER		1
15150-107	BEARING	6202	4
15150-108	NYLON NUT	1/4"-20UNC	14
15150-109	PAD		2
15150-110	SHAFT JOINT		2
15150-111	SCREW	1/4"-20UNCX1/4"L	2
15150-112	ELECTRIC CONTROL BOX		1
15150-113	ELECTRICAL INSULATION BOARD		1
15150-114	PHILLIPS HEAD SCREW	M5X0.8X10	2
15150-115	SAFETY SWITCH		1
15150-116	PLASTIC CLAMP		1
15150-117	PLASTIC CLAMP	6P-4	1
15150-118	SPEED REDUCTION MOTOR		1

PARTS LIST - 15-150 M1

PART NO.	DESCRIPTION	SPECIFICATION	QTY
15150-119	PC BOARD		1
15150-120	REGULATOR KNOB		1
15150-121	PC BOARD MOUNTING PLATE		1
15150-122	BOTTOM COVER, ELECTRIC CONTROL BOX		1
15150-123	PHILLIPS HEAD SCREW	3/16"-24UNCX1/4"L	18
15150-124	CAP SCREW	1/4"-20UNCX3/4"L	16
15150-125	FOOT		2
15150-126	FRONT PANEL		1
15150-128	FOOT PAD		4
15150-129	SCREW	5/16"-18UNCX5/8"L	4
15150-130	CAP SCREW	5/16"-18UNCX4"L	2
15150-131	PRESSURE ROLLER	FRONT	1
15150-131A	PRESSURE ROLLER	REAR	1
15150-132	BUSHING		4
15150-133	CIRCLIP	S28	1
15150-134	PHILLIPS HEAD SCREW	1/4"-20UNCX5/8"L	12
15150-135	V-BELT		1
15150-136	CONVEYOR BELT		1
15150-137	POWER CORD		1
15150-138	CORD		1
15150-139	SWITCH WIRE		2
15150-140	WIRE WITH TERMINALS		2
15150-142	SANDING BELT (SEE 15-255)	P120	1
15150-143	WARNING LABEL		1
15150-144	WARNING LABEL		1
15150-145	COVER CUSHIONS		2
15150-147	COVER PANEL		1
15150-148	OPEN END WRENCH	12/14MM	1
15150-149	T HANDLE ALLEN WRENCH	6MM	1
15150-149A	T HANDLE ALLEN WRENCH	2MM	1
15-150-149B	ALLEN KEY	5 MM	1
15-150-161	SPACER		1
15150-170	MOUNTING BRACKET		2
15150-171	MOTOR PLATE SHAFT		1
15150-174	SHAFT		1
15150-175	TABLE SUPPORT BRACE		1
15150-180	POST COVER		2
15150-182	MOTOR RETAINING COLLAR		2
15150-183	HEX NUT	3/8"-16UUNC	4
15150-184	HEX SCREW	3/8"-16UNCX2L	2
15150-185	SET SCREW	1/4"-20UNCX1-1/2L	4
15150-186	REAR COVER		1
15150-187	TOP REAR COVER		1
15150-188	FRONT SHIELD		1
15150-189	NUT	1/4"-20UNC	8
15150-190	LOCK NUT	5/16"-18UNC	4
15150-191	SET SCREW	3/16"-24UNCX3/8L	4
15150-192	LOCK WASHER		8
15150-193	SCREW	1/4"-20UNCX3/8"L	1

15-150 M1



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Canada H1P 1Y3

Tel.: (514) 326-1161

Fax : (514) 326-5565 Parts & Service

Fax : (514) 326-5555 Order Desk

orderdesk@general.ca

www.general.ca

IMPORTANT: When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.